

Work Order ID 58631

Wednesday, May 12, 2010 1:14:41 PM \

Page 1

Item ID: D3691-1

Revision ID:

Item Name: STUD

Start Date: 5/13/2010 Start Qty: 36.00

Required Date: 5/21/2010 Req'd Qty: 36.00

Reference:

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Approvals:

Process Plan: UMF

Date: 10-5-12

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3691

Rev D

100

0.00



BAND SAW

Bandsaw

Memo

0.00

Jeaspa Bandsaw

DO NOT USE CHOP SAW

☐ Cut blank 7.850" long

SL 10/06/03

110

0.00



DOOSAN LATHE

Doosan

Memo

0.00

Doosan Lathe

1-Turn as per Folio FA716 Rev: AA & Dwg D3691 Rev: D ☐ 2-Deburr

per dwg D3691

3-Check .625" bore with DT9530 GO/NO GO Gauge

SL 10/06/03 37

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC



Memo

0.00

Quality Control

SL 10/06/03

Dart Aerospace Ltd

| W/O: 58631 | | WORK ORDER CHANGES | | | | | |
|------------|------|--|---|----------|-----|-------------------------------------|---|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| 10/06/03 | | Perm Change operation 130, 140, 150, 160 need to be remove from w/o. |  | 10/06/03 | | |  10/06/03 |
| | | | | | | | |

Part No: D3691-1 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 58631

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Item ID: D3691-1

Accept



Setup Start



Revision ID:

Stop



Item Name: STUD

Start Date: 5/13/2010 Start Qty: 36.00



Cust Item ID:

Required Date: 5/21/2010 Req'd Qty: 36.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Lathe Conv

Conventional Lathe

CONVENTIONAL LATHE

Memo

Face to finished length as per dwg D3691 AND center drill as per Dwg D3691

0.00

0.00

140



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

0.00

150



Doosan

Doosan Lathe

DOOSAN LATHE

Memo

1- Turn as per Folio FA716 Rev: _____ & Dwg D3691 Rev: _____ ☐ 2-Deburr
per dwg D3691

0.00

0.00

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Work Order ID 58631

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Item ID: D3691-1

Accept

Revision ID:

Item Name: STUD

Start Date: 5/13/2010 Start Qty: 36.00

Required Date: 5/21/2010 Req'd Qty: 36.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center ID

160



QC

Quality Control

Operation
Description

QC2- Inspect parts off machine FAI/FAIB

Memo

Set Up/
Run Hours

0.00

0.00

Draw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

0.00

171



Purchasing

Purchasing

Memo

Liquid Penetrant Inspection as per QSI 038

Issue P/O: 12121

LPI as per dwg D3691

Attach copy of NDT results to work order

0.00

0.00

CY 10/6/18

(37)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

Work Order ID 58631

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Wednesday, May 12, 2010 1:14:41 PM

Item ID: D3691-1

Accept



Setup Start



Revision ID:

Stop



Item Name: STUD

Start Date: 5/13/2010 Start Qty: 36.00



Cust Item ID:

Required Date: 5/21/2010 Req'd Qty: 36.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

173

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

Memo

0.00

Packaging

P. 10/1/18 (37)

175

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

ml 10 06 21 (37)

180

Identify as per dwg & Stock Location: 078

0.00



Packaging

Memo

0.00

Packaging

P. 10/1/21 (37)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 58631

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Item ID: D3691-1 Accept  Setup Start 
Revision ID:
Item Name: STUD Stop 
Start Date: 5/13/2010 Start Qty: 36.00  Cust Item ID:
Required Date: 5/21/2010 Req'd Qty: 36.00  Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start 
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop 

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Draw Number | Draw Rev. | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|----------------|--------------|--------------|---------------|---------------|------------------|----------------|

190



QC


Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

10/06/22 

MF 10-6-21

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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NOTE: Date & initial all entries

Picklist Print

Wednesday, May 12, 2010 1:14:41 PM

Page 1

Work Order ID: 58631



Parent Item: D3691-1



Parent Item Name: STUD

Start Date: 5/13/2010

Required Date: 5/21/2010

Comments: IPP Rev:A New Issue 08-01-29 JLM Verified By:EC
IPP Rev:B Material Change 09-01-07 JLM Verified By:EC IPP
REV:C AS PER REV D 10-03-16 JLM VERIFIED BY:EC
IPP Rev:C Added note on Step 2 09-01-26 JLM Verified By:EC

Start Qty: 36.00

Required Qty: 36.00

M174PH-H900R1.000

Purchased

No

f

63.1000

0.73



17-4SS H900 ROUND BAR 1.00

Location

Loc Qty

Loc Code

MAT030

63.1

112374

1.5

112570

61.6

1.5
24

SL 10/05/26

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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NOTE: Date & initial all entries

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|------------------------------|---------------|-----------------------------|
| DART AEROSPACE LTD | | Work Order: 58631 |
| Description: Stud | | Part Number: D3691-1 |
| Inspection Dwg: D3691 | Rev: D | Page 1 of 1 |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|-----------------|------------------|--------|--------|----------------------|----------|
| Ø0.695 | +/-0.010 | .691 | ✓ | | | |
| 45° | 0.5° | 45° | ✓ | | | |
| 0.625 | +0.004/-0.000 | .627 | ✓ | | | |
| 1.25 | +0.000/-0.03 | 1.235 | ✓ | | | |
| 118° | 0.5° | 118° | ✓ | | | |
| R0.03 | +/-0.030 | .030 | ✓ | | | |
| 0.11 Ref | +/-0.030 | .11 | ✓ | | | |
| 90° | 0.5° | 90° | ✓ | | | |
| Ø0.189 | +0.005/-0.001 | .191 | ✓ | | | |
| 1.31 | +/-0.030 | 1.305 | ✓ | | | |
| 1.65 | +/-0.030 | 1.650 | ✓ | | | |
| 0.750 | +0.000/-0.010 | .745 | ✓ | | | |
| Ø0.659 | +0.000/-0.015 | .653 | ✓ | | | |
| 7.625 | +/-0.015 | 7.625 | ✓ | | | |
| 2.90 | +/-0.030 | 2.910 | ✓ | | | |
| 3/4-16UNF-2A | N/A | ✓ | ✓ | | | |
| 0.075 x 45° | +/-0.010 x 0.5° | .080 x 45° | ✓ | | | |
| 0.375 | +0.000/-0.010 | .370 | ✓ | | | |
| Ø0.189 | +0.005/-0.001 | .191 | ✓ | | | |
| R0.25 | +/-0.030 | .250 | ✓ | | | |
| R0.50 | +/-0.030 | .500 | ✓ | | | |

| | |
|---------------------|--------------------|
| Measured by: | <i>[Signature]</i> |
| Date: | 10/06/03 |

| | |
|--------------------|--------------------|
| Audited by: | <i>[Signature]</i> |
| Date: | 10/26/02 |

| | |
|----------------------------|-----|
| Prototype Approval: | N/A |
| Date: | N/A |

| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------------------|------------|--------------------|
| A | 09.05.11 | New Issue | KJ | |
| B | 09.11.04 | Dwg Rev updated | KJ | |
| C | 10.03.31 | Dimensions revised per Dwg Rev D | KJ | <i>[Signature]</i> |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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NOTE: Date & initial all entries

8

7

6

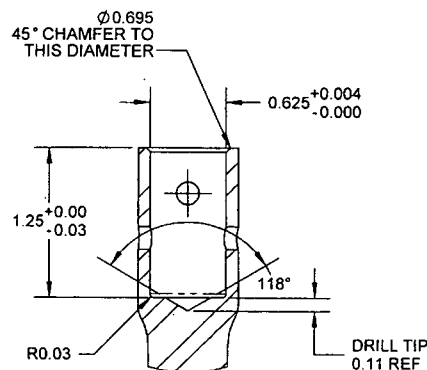
5

4

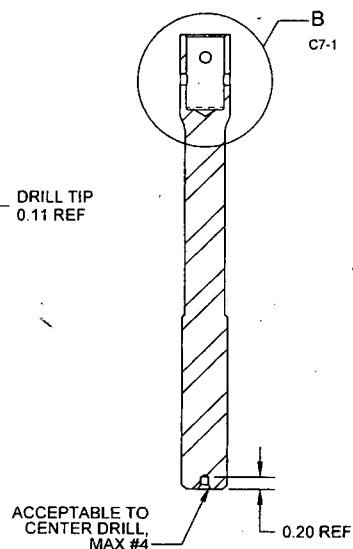
3

2

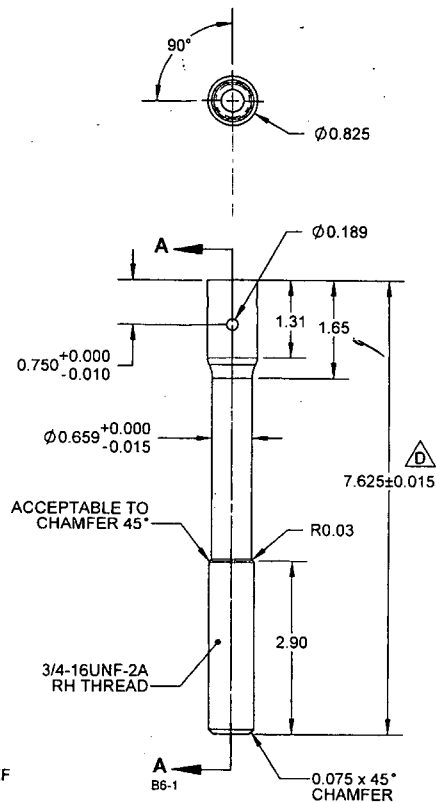
1



DETAIL B
SCALE 2X
C6-1



SECTION A-A
D4-1



D3691-1 STUD

NOTES:

- 1) MATERIAL: 17-4PH STAINLESS STEEL ROUND BAR PER AMS 5643 H-900 CONDITION
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.81 lb
- 8) LPI PER QSI 038 4.1.1 (ASTM E1417 LEVEL 2)

RELEASED
2010-03-15

| D | 7.625 WAS 7.750 (ZN C4-1) | RF | 10.03.03 |
|---|--|----|----------|
| C | 0.20 WAS 0.16 & CENTER DRILL #4 WAS CENTER DRILL #2 (ZNB6-1); UPDATE NOTE 8 TO REF QSI (ZN A8-1) | RF | 09.09.09 |
| B | CHANGE TO 17-4PH H-900(ZN A8-1); Ø0.695 WAS Ø0.665 (ZN D8-1); REFORMATTED TO CURRENT DWG STANDARDS | RF | 08.11.24 |
| A | NEW ISSUE | RF | 08.03.12 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | RF | | |
| DRAWN | RF | | |
| CHECKED | | | |
| MFG. APPR. | | | |
| APPROVED | | | |
| DE APPR. | | | |
| DATE | 10.03.03 | | |
| DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3691 TITLE STUD REV. D SHEET 1 OF 1 SCALE NTS COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD. | | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries



LIQUID PENETRANT TEST REPORT

P- 15326

PAGE 1 OF 1

CLIENT DART AEROSPACE DATE JUNE 18-2010 TIME AM ☒ PM ☐
ATTENTION LINDA ACUREN JOB No. 188-10-0769
ADDRESS 1270 ABERDEEN ST. POWO No. 172/21 -
HAWKESBURY ON. WORK LOCATION RAW SHOP - HAWKESBURY
K6H 1K7 ACCEPTANCE STD. _____ REV./DATE _____
PROJECT F.P.I. ON CROSS TUBES AND MACHINED PARTS
ITEM(S) EXAMINED 5 - CROSSTUBES.
57 - MACHINED PARTS

JOB DESCRIPTION _____ PROCEDURE No. LT-0002 REV./DATE _____ TECHNIQUE No. LT-TECH2 REV./DATE _____
PART No. _____ MATERIAL ALUMINE ALUMINUM THICKNESS VARIOUS
SCOPE -WET FLUORESCENT LIQUID STAINLESS STEEL
PENETRANT INSPECTION CARRIED OUT 100% EXTERNAL

TEST DETAILS

METHOD ☒ FLUORESCENT ☐ VISIBLE ☒ WATER WASH ☐ SOLVENT REMOVABLE ☐ POST EMULSIFIED
FAMILY BRAND MAGNA FLUX BLACK LIGHT S/N 16459 ☐ OUTPUT > 1000 μ W/cm² ☐ AMBIENT < 2 fc
PENETRANT 2607 MINIMUM DWELL TIME 45 MIN. LIGHTING EQUIP. ☐ FLASHLIGHT ☐ TROUBLELIGHT ☐ OUTPUT > 100 fc @ SURFACE
PENETRANT REMOVER 170 MINIMUM DRY TIME >10 MIN. OTHER LABINO
DEVELOPER SKD 52 MINIMUM DWELL TIME 10 MIN. LIGHT METER S/N 1098866 CAL DUE DATE
DEVELOPER TYPE ☒ NON AQUEOUS ☐ AQUEOUS ☐ DRY 06-19-2010

TEST SURFACE

SURFACE CONDITION ☐ AS GROUND ☐ AS WELDED ☒ MACHINED ☐ SHOT BLASTED ☒ CLEAN BARE METAL
SURFACE TEMPERATURE ☐ < -4°C/ 20°F ☐ -4°C/ 20°F TO 10°C/50°F ☒ 10°C/50°F TO 52°C/125°F ☐ > 52°C/125°F

RESULTS- (☐ METRIC ☐ IMPERIAL)

| | |
|-----------------------------|---|
| 1 - W.O. 59047 - CROSS TUBE | ✓ |
| 1 - W.O. 59026 - CROSS TUBE | ✓ |
| 1 - W.O. 59027 - CROSS TUBE | ✓ |
| 1 - W.O. 59278 - CROSSTUBE | ✓ |
| 1 - W.O. 59279 - CROSS TUBE | ✓ |
| 37 - W.O. 58631 - STUDES | ✓ |
| 20 - W.O. 58634 - SLEEVE'S | ✓ |

[Signature] 10-08-21

Scope of Services

The agreement of Acuren Group Inc. to perform services extends only to those services provided for in writing. Under no circumstances shall such services extend beyond the performance of the requested services. It is expressly understood that all descriptions, comments and expressions of opinion reflect the opinions or observations of Acuren Group Inc. based on information and assumptions supplied by the owner/operator and are not intended nor can they be construed as representations or warranties. Acuren Group Inc. is not assuming any responsibilities of the owner/operator and the owner/operator retains complete responsibility for the engineering, manufacture, repair and use decisions as a result of the data or other information provided by Acuren Group Inc. In no event shall Acuren Group Inc.'s liability in respect of the services referred to herein exceed the amount paid for such services.

Standard of Care

In performing the services provided, Acuren Group Inc. uses the degree, care and skill ordinarily exercised under similar circumstances by others performing such services in the same or similar locality. No other warranty, expressed or implied, is made or intended by Acuren Group Inc.

SIGNATURES

| | | |
|---|----------------------------------|---------------------|
| CLIENT REPRESENTATIVE <u>JASON MURCLOCH</u> | <u>[Signature]</u> | DTR # <u>E27415</u> |
| TECHNICIAN (SIGNATURE): <u>[Signature]</u> | | REPORT REVIEWED BY: |
| NAME (PRINT): <u>MIKE SCHWARTZ</u> | | NAME INITIALS |
| CGSB LEVEL <u>II</u> SNT LEVEL _____ | CGSB LEVEL _____ SNT LEVEL _____ | |
| CGSB REG. NO. <u>6606</u> | CGSB REG. NO. _____ | |

WHITE - CLIENT COPY

CANARY - OFFICE COPY

PINK - TECHNICIAN COPY

GOLD - OFFICE COPY